

# Work Order ID 95569



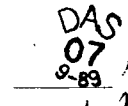
Monday, January 14, 2013 10:50:31 AM

**\*95569\***

Page 1

Item ID: D3888-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Full Height Comfort Window, LH  
 Start Date: 1/14/2013 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 1/31/2013 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M Date: 13-01-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3888	<u>PA1 A Dh.</u>								
100		0.00							<u>xl</u> 
<b>*100*</b>	HAND FINISHING THERMOFORMING								
Thermoform	<b>Memo</b>	0.00							
Thermoforming Machine	Set up Machine as per folio FTA130 and D3676 program								13/1/14
110		0.00							
<b>*110*</b>	HAND FINISHING THERMOFORMING								
Thermoform	<b>Memo</b>	0.00							
Thermoforming Machine	Cut Blanks to 30" by 48"								13/1/14
120		0.00							
<b>*120*</b>	THERMOFORMING MACHINE								
Thermoform	<b>Memo</b>	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3888-1 and Folio FTA 130 Rev. <u>13</u> Folio Rev. <u>A</u>				Dwg.				13/1/14
	Visually inspect for proper formation and clarity								

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Item ID: D3888-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Full Height Comfort Window, LH

Start Date: 1/14/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
<b>*150*</b>	HAND FINISHING THERMOFORMING					1			DAS 07 9-89
Thermoform	Memo	0.00							
Thermoforming Machine	1) Trim off excess flange material2) Buff out any light scratches or blemishes3) Etch part number and batch number								13/01/21
160		0.00							
<b>*160*</b>	QC2- Inspect parts off machine FAI/FAIB					1			DAS 07 9-89
QC	Memo	0.00							
Quality Control									13/01/21
170		0.00							
<b>*170*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								

DAS  
16  
9-89

HAI

13/1/23

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Item ID: D3888-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Full Height Comfort Window, LH  
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Required Date: 1/31/2013 Req'd Qty: 1.00 **\*1\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

MCJ 13-02-01

113-02-1

# Picklist Print

Page 1

Monday, January 14, 2013 10:50:37 AM

Work Order ID: 95569

**\*95569\***

Parent Item: D3888-1

**\*D3888-1\***

Parent Item Name: Full Height Comfort Window, LH

Start Date: 1/14/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A New Issue 12/01/19 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRYLICS.177

Purchased

No

sf

346.6600

13.68421

**\*MACRYLICS 177\***

**\*\***

0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SHEET

DAS  
07  
89

13/01/21

Location

Loc Qty

Loc Code

therm

346.66

119505

14.66

120972

44

122537

288

13.68559 RT.

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 95569
<b>Description:</b>	<b>Part Number:</b> D3888-1
<b>Inspection Dwg:</b> D3888-1 Rev: A ok.	<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> <u>Wh</u>	<b>Date:</b> 13/01/14
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### TRIMMING SECTION

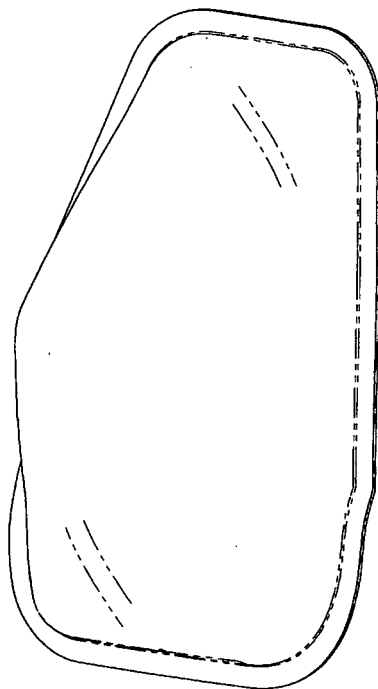
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.1	$\pm 0.100$	29.1"	✓			
46.0	$\pm 0.100$	46.1"	✓			
0.090"	Min.	0.095"	✓			

<b>Measured by:</b> <u>DAS</u>	<b>Date:</b> 13/01/21
<b>Audited by:</b> <u>16</u>	<b>Date:</b> <u>13/1/23</u>
<b>Preliminary Approval:</b> <u>9-89</u>	<b>Date:</b> <u> </u>

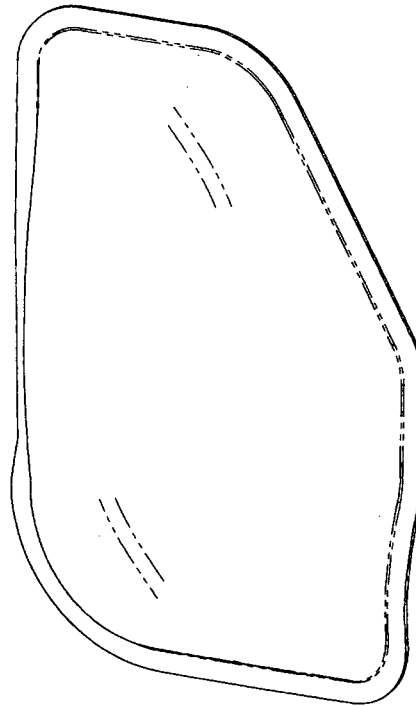
Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

95569  
PL1301-14



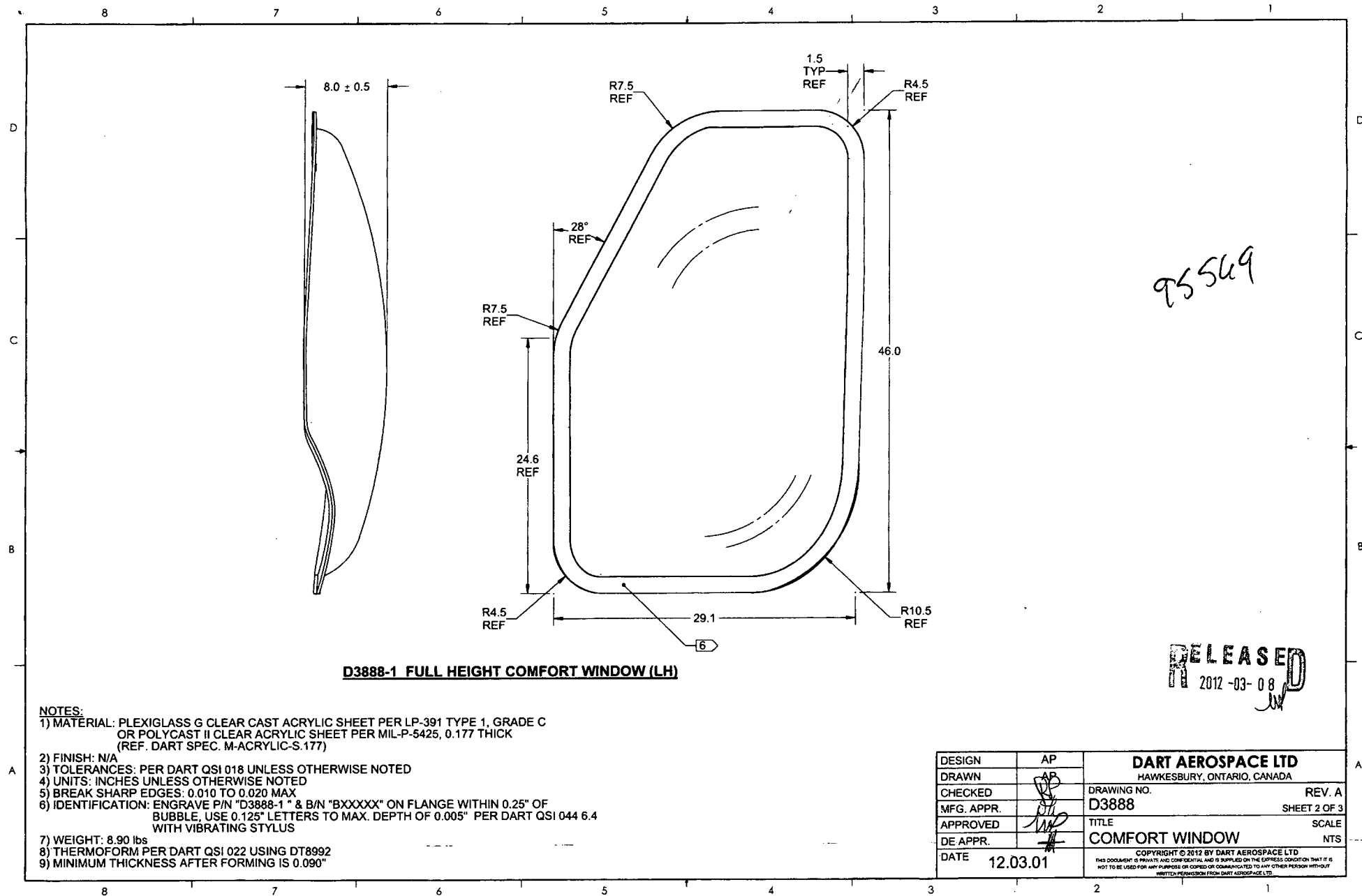
**D3888-1 FULL HEIGHT COMFORT WINDOW (LH)**

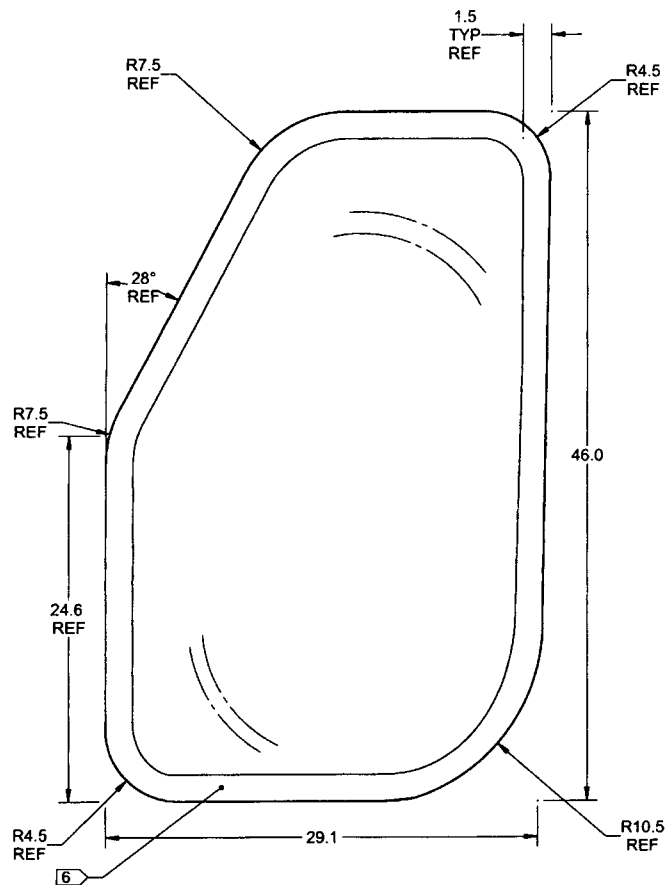


**D3888-2 FULL HEIGHT COMFORT WINDOW (RH)**

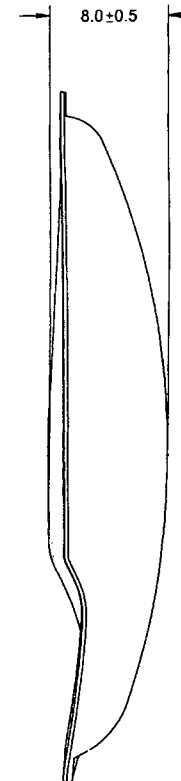
RELEASED  
2012-03-08

A		NEW ISSUE		AP	12.03.01
REV.	DESCRIPTION			BY	DATE
DESIGN	AP	DART AEROSPACE LTD		REV. A	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 3	
CHECKED	[Signature]	DRAWING NO. D3888		TITLE	
MFG. APPR.	[Signature]	FULL HEIGHT COMFORT WINDOW		SCALE NTS	
DE APPR.	[Signature]	DATE 12.03.01		COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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**D3888-2 FULL HEIGHT COMFORT WINDOW (RH)**



95569

RELEASED  
2012-03-08

**NOTES:**

- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1, GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.177 THICK (REF. DART SPEC. M-ACRYLIC-S.177)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D3888-2" & B/N "BXXXXX" ON FLANGE WITHIN 0.25" OF BUBBLE, USE 0.125" LETTERS TO MAX. DEPTH OF 0.005" PER DART QSI 044 6.4 WITH VIBRATING STYLUS
- 7) WEIGHT: 8.90 lbs
- 8) THERMOFORM PER DART QSI 022 USING DT9794
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.090"

DESIGN	AP	<b>DART AEROSPACE LTD</b>	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D3888	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	FULL HEIGHT COMFORT WINDOW	NTS
DATE	12.03.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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